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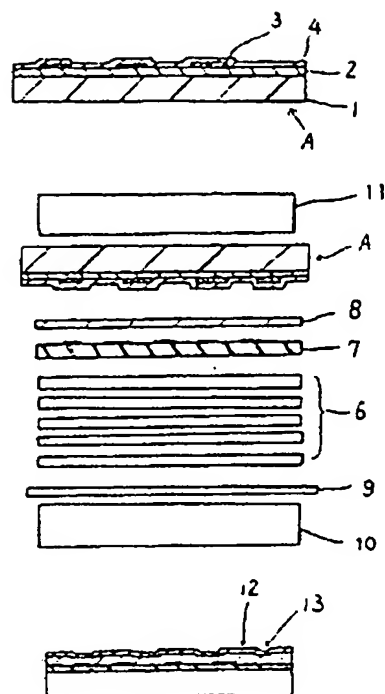
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TITLE : MANUFACTURE OF THERMOSETTING
RESIN DECORATIVE SHEET



ABSTRACT : PURPOSE: To realize a gloss changing pattern excellent in decorative design effect by a method wherein a shaping film, which is produced by providing a pattern layer containing adherent resin and matting agent and a transparent peel ply having the specified thickness on one side of a heat resistant base sheet in the order named, is inserted between a caul plate and semi-set thermosetting resin impregnated papers in such a manner that the pattern layer faces to the resin impregnated paper side so as to form said film and papers under heat and pressure.

CONSTITUTION: A shaping film is obtained by providing a first pattern layer 2, which covers all over the surface of a base sheet 1 and consists of varnish containing favorably adherent resin and matting agent, a second pattern layer 3, the blending ratio of the matting agent in which is different from that in the first pattern layer, and a transparent releasing layer 4, which covers all over the surface of the base sheet by a thickness not less than 0.5 μ m and not more than 2 μ m. The shaping sheet A is put on phenolic resin impregnated core papers 6, a melamine resin impregnated decorative sheet 7 and a melamine resin impregnated overlay paper 8 in the ascending order named and, after that, pinched through a releasing paper 9 between a lower caul plate 10 and an upper caul plate 11 so as to be heated and pressurized. Finally, by peeling off the shaping film, a decorative sheet, which has gloss portions 12 and mat portions 13, is obtained.

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